

Date: Thursday, 5/4/2006 1:09:51 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLOWER MOTOR ADAPTER  
 Job Number : 27025  
 Estimate Number : 12132  
 P.O. Number : NIA Part Number : D34763  
 This Issue : 5/4/2006 S.O. No. : N/A Drawing Number : D3476 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : NIA Type : SMALL / MED FAB Drawing Revision : A  
 Previous Run : 25689 Material : NIA  
 Written By : *See Comment Below* Due Date : 5/28/2006 Qty: 10 Um: Each  
 Checked & Approved By : *06-05-05*  
 Comment : Est Rev:A New Issue 06-01-31 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



## Comment: PURCHASING

Issue P/O: 1197 For D3476-3S

Spin as per Dwg D3476

Possible Supplier: SIEG

Material release note is required

*C 206/05/09 10*

2.0 D34763S DOME, SPINNING DETAIL



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 scoop outlet

3.0 PACKAGING 1 PACKAGING RESOURCE #1



## Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

*C 206/14/06 10*

4.0 QC6 DIMENSIONAL CHECK



## Comment: DIMENSIONAL CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



## Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Layout Hole Position Using Dt8844 Template

2-Drill 2.250" as per Dwg D3476

*FF 06-07-04 10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 5/4/2006 1:09:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ADAPTER

Job Number: 27025

Part Number: D34763

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Flare as per Dwg D3476 Using DT8845 A&B

4-Deburr if Required

FF 06-07-05

8  
10  
PTO

6.0

QC5

INSPECT WORK TO CURRENT STEP



Job 0705

8

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 356

4/6/2/6

DB-

(5)

8.0

DC

DOCUMENT CONTROL



(8)

Comment: DOCUMENT CONTROL

Inspection Level 21


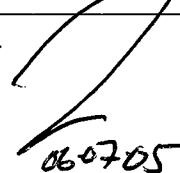

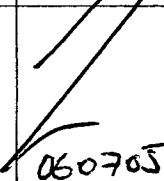
06/07/07


Job Completion



U 060707

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-07-05	5	2 Blower motor adapter flange cracked at flaring		Destroy, No more to replace	FF 06.07.05	 060705	 060705	 060705

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/07/07

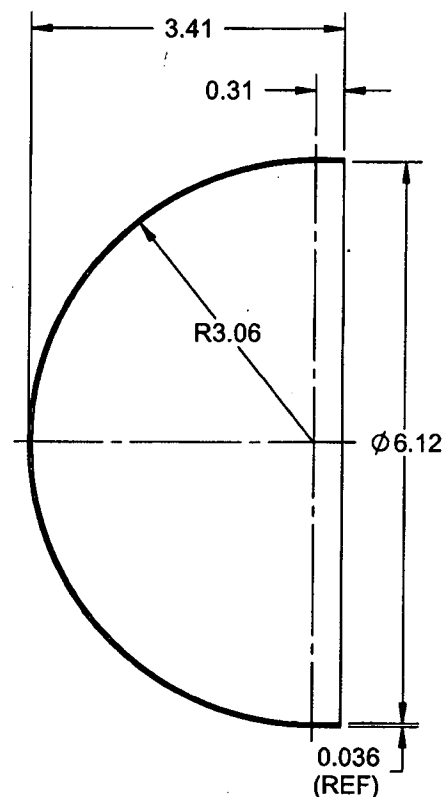
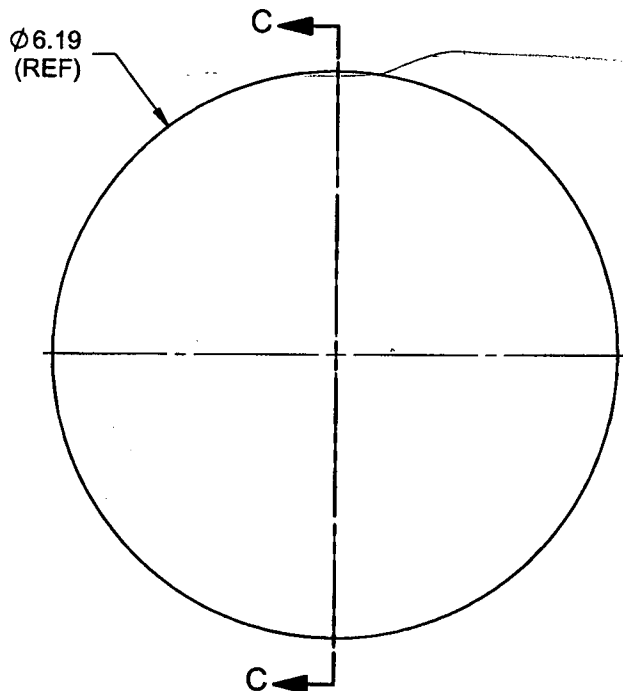
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3476	REV. A SHEET 4 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

RELEASED  
06.04.03 *[Signature]*



**SECTION C-C**

**D3476-3S DOME, SPINNING DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.036 THICK PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S20GA)
- 2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING OF MATERIAL (MINIMUM THICKNESS = 0.025").
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE

WORK ORDER  
NO. 27025

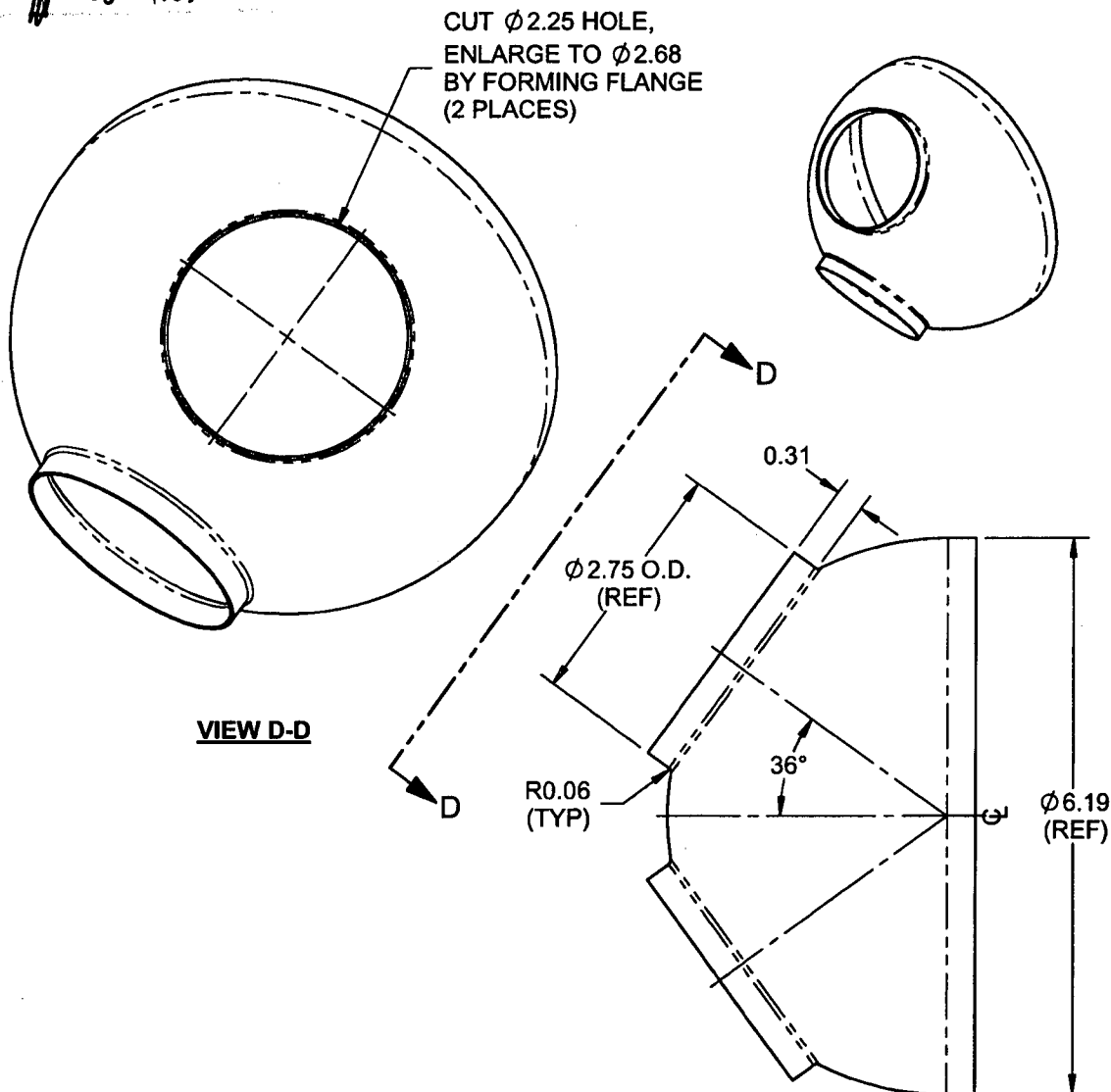
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3476	REV. A SHEET 5 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

# 06.04.03



### D3476-3 DOME

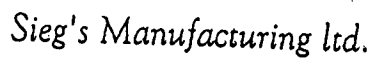
#### NOTES:

- 1) MATERIAL: MAKE FROM D3476-3S
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 27025

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604 530-7455 fax 604 530-7490  
6236-205 Street, Langley, British Columbia. Canada. V2Y 1N7

# INSPECTION REPORT

DATE: June 9/06

CUSTOMER: Dart Aerospace

INVOICE #: 30308 SUPPLIER #:

DESCRIPTION OF INSPECTION:

NOTES OF INSPECTION:

NOTES OF REJECT:

02/23/06 THU 14:14 FAX 6045209808  
Mill Test Report

ABSTRACT INT'L METALS

HIN: Arla

2001  
Page 1 of 1



## MILL TEST REPORT

TA CHEN INTERNATIONAL, INC.  
www.tachen.com

This MTR contains 1 page (Page: 1)

MTR#: ACCL10542

Item#: 20GA48120316L2B

 <b>ThyssenKrupp Nirosa</b> Ein Unternehmen von ThyssenKrupp Stahl AG		<b>ABNAHMEPRUEFZEUGNIS 3.1</b> <b>INSPECTION CERTIFICATE 3.1</b> <b>CERTIFICAT DE RECEPTION 3.1</b> <b>EN 10204</b>		Zeugnis-Nr.: 051101471 Certificate No.: N° du certificat: <i>ACCL10542</i> Datum: 20.04.2005 Date:						
<b>47704 Krefeld</b> Postfach <b>THYSSENKRUPP NIROSTA</b> <b>2275 HALF DAY ROAD, SUITE 160</b> <b>USA- BANNOCKBURN, IL 60015</b> <b>USA</b>		Bestellung / Purchase: Contract-Nr.: <b>THYSSENKRUPP NIROSTA</b> OC 00002449 - PO L13512 Liefer-Auftrag Nr.: Our Order No.: 278140 Unsere commande:		Lieferungs-Nr.: Delivery Note No.: 86437223 Avis d'expédition N°: Zeichen d. Sachverständigen: Inspector's stamp:  Paten des Import						
Erzeugnisform: Product: Werkstoff: Quality: Material: <b>Blech/Sheet/Plate</b> <b>TYPE 316/316 L</b>		Lieferbedingungen/Terms of delivery/Conditions de livraison: <b>ASTM A 240/A 240M-04a</b> <b>ASME SA 240 Sec. II Part A Ed.04</b> <b>ASTM A 480/A 480M-04 ASME SA 480/SA-480M 01</b> <b>ASTM A 688-03</b> <b>SAE AMS 5507 F</b> <b>SAE AMS 5524 K</b>								
Position Item Poste	Stückzahl Quantity Métrique	Gewicht/Masse LBS	Maße/Produkt dimensions/Dimensions du produit Inch			Erzeugnis-Art Mat. furn. Made de	Schweiß-Nr. Cath-No. Cathén N°	Lief.-Best-Nr. Lot-Cat-No. Lot- Rechnung-N°	Anmerkung Finch Pm	
10	629	36953	0,0350 x 48,0000 x 120,0000			AOD		22056	3C2B	
Schweiß-Nr. Cath-No. Cathén N°	C %	Si %	Mn %	P %	S %	Cr %	Mo %	Ni %	N %	Cu %
484447	0,02	0,37	0,86	0,029	0,001	16,85	2,02	10,54	0,037	0,23
Probe Number Test No. Essai	Lief.-Best-Nr. Lot-Cat-No. Lot- Rechnung-N°	Rp0,2 %	Rp1% %	Rm %	A2 %	HV	KO	GL/BT %		
596 A	22056 00	47555	51325	91195	49,8	163,0	10,0	17,0		
596 E	22056 00	48135	51780	91920	50,0	164,0	10,0	17,0		
Probenlage auf Werkfläche QUER	KO Korngröße / Grain Size nach ASTM E 112 GL/BT Glanz bei 20 Grad (BRIGHTNESS TEST-USA)									
Vervachungsprüfung (Spektralanalyse)/Test of identity (spectrum analysis)/Contrôle d'identification (analyse spectrale) Maße - Oberflächen/Dimensions - Surfaces/Dimensions - Surfaces Prüfung auf Intermetall. Korros./Test of intermetal. corros./Test de corros. intermetall. EN ISO 3651-2						I.O. LO. O.B.				
<b>ThyssenKrupp Nirosa GmbH</b> DIESES ZEUGNIS WURDE VOM RECHNER ERSTELLT WERK KREFELD, ABNAHME BUTZEN ABNAHMEBEAUFTRAGTER INSPECTION REPRESENTATIVE TEL: 02151-832447 FAX: 02151-834106						Frei von Quecksilber / free of mercury NO MERCURY WÄRMEBEHANDLUNG : 1050 GRAD C / LUFT TRAITEMENT THERMIQUE : 1050 GRAD C / AIR HEAT - TREATMENT : 1050 DEGREE / AIR				
						8892721 8892723 8892741 8892747 8892748 8892749 8892750 8892760 8892762 8892763 8892765				

# 484447

20 ga.

48" x 120"

316

SHEET